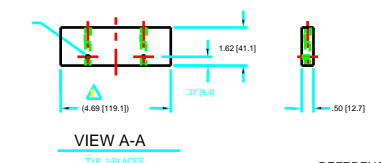
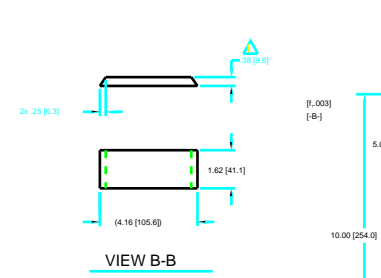
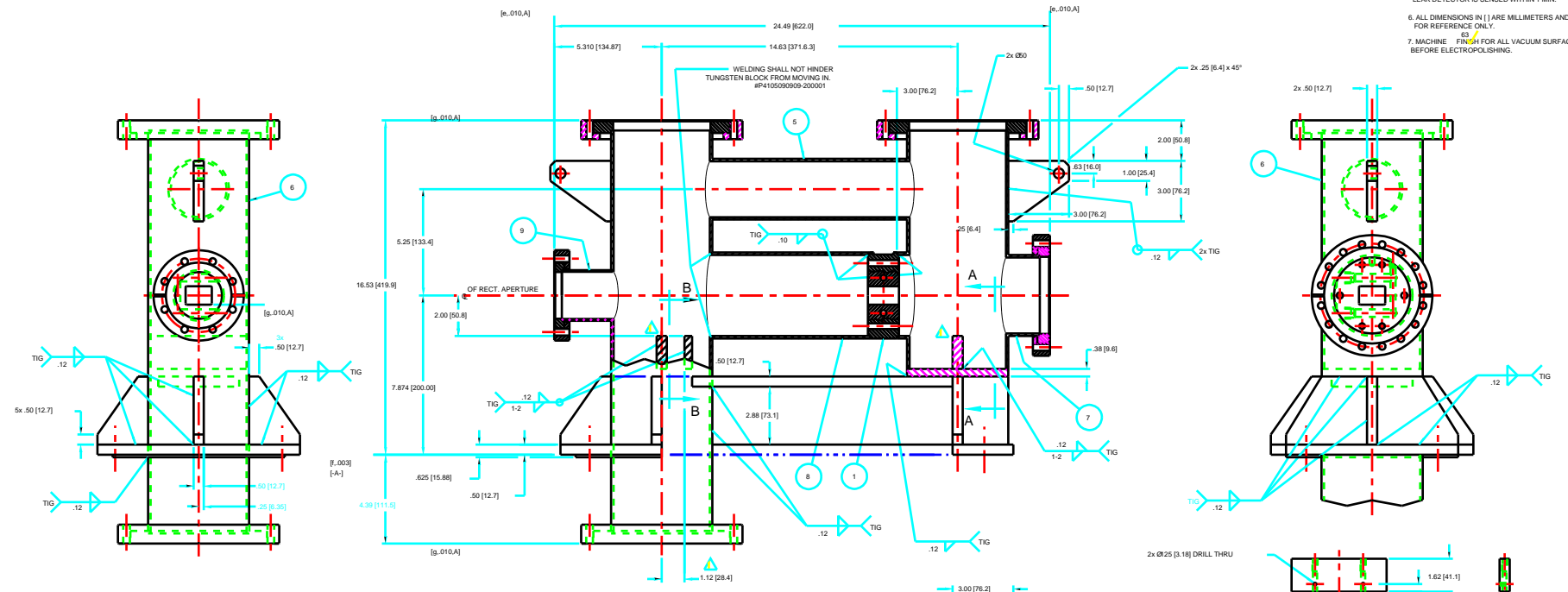
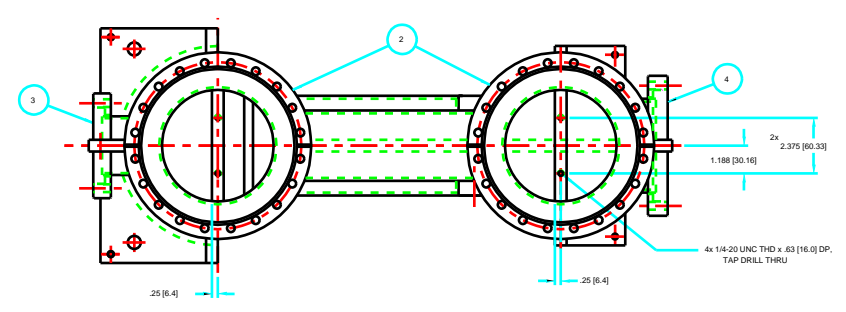


- NOTE:
1. THIS IS A ULTRA-HIGH VACUUM CHAMBER (UHV).
  2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
  3. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE CHAMBER NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN. THE CHAMBER VACUUM SIDE SURFACE ROUGHNESS SHALL BE BETTER THAN 63 MICRON IN RMS AFTER ELECTROPOLISHING.
  4. WELD SHALL BE GAS TUNGSTEN ARC (GTAW) OR TUNGSTEN INERT GAS (TIG) ON VACUUM SIDE OF JOINTS.
  5. VACUUM CHAMBER SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF  $2 \times 10^{-10}$  STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:  
ALCATEL ASM-110TCL  
VARIAN NCR 925 OR 936  
VEECO MSA-8, MS-80 OR MS-18  
DuPONT CEC 24-120B  
CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING. FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
  6. ALL DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.
  7. MACHINE FINISH FOR ALL VACUUM SURFACE BEFORE ELECTROPOLISHING.



REFERENCE SOURCE  
MDC VACUUM PRODUCTS CORP.  
23842 CABOT BOULEVARD  
HAYWARD, CA 94545-1651  
(800) 443-8817

PARTS LIST			
1	TUBING 2.50 O.D. x .065 WALL	304 SST	1
2	TUBING 4.25 O.D. x .120 WALL	304 SST	2
3	TUBING 4.00 O.D. x .120 WALL	304 SST	1
4	TUBING 5.00 O.D. x .120 WALL	304 SST	2
5	TUBING 3.00 O.D. x .120 WALL	304 SST	1
6	FLANGE 6" NOM. ROTATABLE	304 SST	1
7	FLANGE 4-1/2" NOM. ROTATABLE	304 SST	1
8	FLANGE 8" NOM. ROTATABLE	304 SST	3
9	P4105090909-210001	304 SST	1
10	P9-20 COOLING BLOCK	304 SST	1
TOTAL: 15 PARTS			

MATERIALS LIST			
1	304 SS	2/8/95	0.51195
2	304 SS	5/11/95	5.12395
3	304 SS	5/11/95	5.12395
4	304 SS	5/11/95	5.12395
5	304 SS	5/11/95	5.12395
6	304 SS	5/11/95	5.12395
7	304 SS	5/11/95	5.12395
8	304 SS	5/11/95	5.12395
9	304 SS	5/11/95	5.12395
10	304 SS	5/11/95	5.12395
TOTAL: 15 PARTS			

1	304 SS	2/8/95	0.51195
2	304 SS	5/11/95	5.12395
3	304 SS	5/11/95	5.12395
4	304 SS	5/11/95	5.12395
5	304 SS	5/11/95	5.12395
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7	304 SS	5/11/95	5.12395
8	304 SS	5/11/95	5.12395
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TOTAL: 15 PARTS			